

Work Order ID 140909

140909

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Item ID: D205-803-121 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Left Hand Pilot In Command - Slim Design, Complete 205
 Start Date: 1/22/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/27/2016 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: SH Date: 20160122 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D212-803	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D205-803-121 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

Ship Jan 27/16

JAN 1 2016

JAN 2 5 2016

JAN 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D205-803-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Left Hand Pilot In Command - Slim Design, Complete 205
Start Date: 1/22/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/27/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00					DAS 28 9-89		JAN 1 2016
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-803-121								
	Location: <u>FG19</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ JAN 26 2016

MLJ JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 140909

140909

Parent Item: D205-803-121

D205-803-121

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 205

Start Date: 1/22/2016

Required Date: 1/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5046-047		Manufactured	No				Each	1.0000		1			
D5046-047									**				
Co-Pilot Collective Head Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST372				1					
				116449				1					
D5049-1		Manufactured	No				Each	30.0000		1			
D5049-1									**				
Face Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST145				30					
				119803				30					
D4410-9		Manufactured	No				Each	5.0000		1			
D4410-9									**				
Trigger													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST095				5					
				116420				5					
D5055-1		Manufactured	No				Each	6.0000		1			
D5055-1									**				
Placard													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST140				6					
				139538				6					

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Parent Item: D205-803-121

D205-803-121

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 205

Start Date: 1/22/2016

Required Date: 1/27/2016

Start Qty: 1.00

Required Qty: 1.00

D5055-3

Manufactured No

Each

3.0000

1

D5055-3

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

ST176

3

146 139609

3

2PB744-T2

Purchased No

Each

8.0000

1

2PB744-T2

Switch

DAS
28
9-89

Location

Loc Qty

Loc Code

ST576

8

m129318

8

AN565F8H9

Purchased No

Each

30.0000

1

AN565F8H9

Set Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST330

30

m129036

30

C100E2-39

Purchased No

Each

2.0000

1

C100E2-39

Switch

DAS
28
9-89

Location

Loc Qty

Loc Code

ST558

2

m129387

2

M39029/31-240

Purchased No

Each

36.0000

17

M39029/31-240

Pin

DAS
28
9-89

Location

Loc Qty

Loc Code

ST556

36

m128795

36

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Parent Item: D205-803-121

D205-803-121

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 205

Start Date: 1/22/2016

Required Date: 1/27/2016

Start Qty: 1.00

Required Qty: 1.00

M39029/32-259

Purchased

No

Each

43.0000

17

M39029/32-259

Socket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST556

43

m128795

43

Each

7.0000

1

MS20253-1-065

MS20253-1-7200 Purchased

No

MS20253-1-065

Hinge Pin

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

7

123522

7

Each

1,225.000

1

MS21042L08

Purchased

No

MS21042L08

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

3

m133134

3

ST303

1078

m133483

78

m133922

1000

ST304

43

m128401

32

m131317

11

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Parent Item: D205-803-121

D205-803-121

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 205

Start Date: 1/22/2016

Required Date: 1/27/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,817.000

1

MS21042L3

Nut

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

459

m133790

459

MS27039-1-07

Purchased

No

Each

398.0000

1

MS27039-1-07

Screw

Location

Loc Qty

Loc Code

GA

334

125654

334

ST281

64

m127813

64

MS3126E14-19P

Purchased

No

Each

4.0000

1

MS3126F14-19P

Socket

Location

Loc Qty

Loc Code

ST273

4

124620

4

DAS
28
9-89

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Work Order ID: 140909

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Parent Item: D205-803-121

D205-803-121

Parent Item Name: Left Hand Pilot In Command - Slim Design, Complete 205

Start Date: 1/22/2016

Required Date: 1/27/2016

Start Qty: 1.00

Required Qty: 1.00

MS3120E14-19S

Purchased

No

Each

12.0000

1

MS3120F14-19S

Socket

DAS 27 9-89
6 9-89

Location

Loc Qty

Loc Code

CA

6

DAS
28
9-89

M129682

6

ST273

6

123567

2

124620

4

MS35206-226

Purchased

No

Each

121.0000

5

MS35206-226

Screw

DAS 27 9-89
6 9-89

Location

Loc Qty

Loc Code

ST272

121

123189

8

m127831

113

NAS1197-6

Purchased

No

Each

147.0000

5

NAS1197-6

Washer

DAS 27 9-89
6 9-89

Location

Loc Qty

Loc Code

ST267

147

m123190

9

m128976

18

m128993

120

MS24665-289

Purchased

No

Each

112.0000

2

MS24665-289

Cotter Pin

DAS 27 9-89
6 9-89

Location

Loc Qty

Loc Code

ST288

112

m128973

87

m128995

25

DAS
28
9-89

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Ref. only

6. PARTS LIST - SMALL COLLECTIVE HEAD KITS

Qty -111	Qty -113	Qty -115	Qty -117	Qty -119	Qty -121	Qty -123	Part Number	Description
X							D205-803-111	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X						D205-803-113	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X					D212-803-115	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X				D212-803-117	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X			D212-803-119	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
					X		D205-803-121	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
						X	D205-803-123	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
1	1						D5046-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
		1	1				D5046-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
				1			D5046-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
					1	1	D5046-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205 WITH THE 204-001-290-5 STICK AND THROTTLE ASSY INSTALLED)
1	1	1	1	1	1	1	D5049-1	FACE PLATE
1	1			1	1	1	D4410-9	TRIGGER
1	1			1	1	1	D5055-1	PLACARD
1	1	1	1	1	1	1	D5055-3	PLACARD
		1	1				D5055-5	PLACARD
		1	1				D5055-7	PLACARD
		1	1				D5055-9	PLACARD
1	1	1	1	1			D4411-7	PLACARD
		1					27ET51-T	SWITCH (ALT P/N 212-075-153-3)
1					1		2PB744-T2	SWITCH
		3					30-037-26	DIODE ASSEMBLY
		2					30-037-3	DIODE ASSEMBLY
1	1			1	1	1	AN565F8H9	SETSCREW
		3					AN961-6T	WASHER
		1					51MX5-5-J	SWITCH
1				1			C100E2-38	SWITCH
17		AR (21)			17		M39029/31-240	PIN
17		AR (21)			17		M39029/32-259	SOCKET
		AR (2)					M39029/31-228	PIN
		AR (2)					M39029/32-247	SOCKET
1	1			1	1	1	MS20253-1-065	PIN
		3					MS21042L06	NUT
1	1			1	1	1	MS21042L08	NUT
1	1	1	1	1	1	1	MS21042L3	NUT
		2					MS21044N04	NUT
1	1	1	1	1			MS21919WDG10	CLAMP
		1	1	1			MS21919WDG19	CLAMP
1	1						MS21919WDG20	CLAMP
		1					MS24523-27	SWITCH
		2					MS24693-S7	SCREW
1	1	1	1	1	1	1	MS27039-1-07	SCREW
		1					MS27212-1-3	TERMINAL BOARD
1					1		MS3126E14-19P	PLUG
1					1		MS3120E14-19S	SOCKET
		2					MS3126E16-99P	PLUG
		1					MS3120E16-99S	SOCKET
		3					MS3373-A1	STRIP
5	5	5	5	5	5	5	MS35206-228	SCREW
2	2	2	2	2			NAS1149D0363J	WASHER
5	5	5	5	5	5	5	NAS1197-6	WASHER
					2	2	MS24665-289	COTTER PIN
1	1	1	1	1	1	1	D212-803	KIT PAPERWORK

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Revision: D
Date: 14.09.18